

Work Order ID 73105

Wednesday, September 14, 2011 2:26:37 PM



Page 1

Item ID: D412-785-002-201

Accept



Setup Start



Revision ID:

Item Name: GPS Mount Assembly

Stop



Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: W Date: _____ Tooling: _____ Date: _____

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Run Start



Stop



Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D412-785-002-10	B								
100	Pick Kit	0.00							
Packaging	Memo	0.00							
Packaging									
110		0.00							
Small Fab	Memo	0.00							
Small Fab	1- Rivet angles as per dwg								
120	QC5- Inspect part completeness to step on W/O	0.00							
QC	Memo	0.00							
Quality Control									

SP11/09/14 (2)

SP11/09/14 (2)

Sulorly

(X2)

Work Order ID 73105

Wednesday, September 14, 2011 2:26:37 PM



Page 2

Item ID: D412-785-002-201

Accept



Setup Start



Revision ID:

Stop



Item Name: GPS Mount Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Run Start



Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Stop



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

0.00



SprayPaint

Memo

0.00

Spray Painting

1- Prime and paint flat black as per dwg

*** Insert screws in nut plate before priming and painting***

Primer B#: 111259

Paint B#: 111259

11 09 15 (2)

140

0.00



QC

QC - Inspect Part Finish

Memo

0.00

Quality Control

11 09 15 (2)

150

0.00



Small Fab

Memo

0.00

Small Fab

1- Install stud as per dwg

11 09 19

(P10) →

W/O: <u>73605</u>		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: D412-785-002-201 PAR #: 02308 Fault Category: Small Fab NCR: Yes No DQA: OK Date: 11/09/19
 Resolution: Scrap + Re-train Disposition: Scrap + Re-train QA: N/C Closed Date: 11/09/19

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action		Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng				
11-09-19	10	2 employees scrapped 4 40-018-1 studs R.C. lack of experience + training (Dug clear next frame)	Initial 11/09/19	Action Description replace studs 50-018-1 B 118933 x 4	11-09-19	8 11/09/19	11-09-19	8 11/09/19

NOTE: Date & initial all entries

Work Order ID 73105

Wednesday, September 14, 2011 2:26:37 PM



Page 3

Item ID: D412-785-002-201

Accept



Setup Start



Revision ID:

Stop



Item Name: GPS Mount Assembly

Start Date: 8/26/2011 Start Qty: 2.00



Cust Item ID:

Required Date: 10/14/2011 Req'd Qty: 2.00



Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

160

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

Quality Control

0.00

5 11/10/19

(42)

170

Receive & Inspect for Damage & Mat'l Certs

0.00



Packaging

ID & STOCK

Memo

Packaging

0.00

11/9/19 (2)

180

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

Quality Control

0.00

11/9/19
ME
11-09-19

Picklist Print

Wednesday, September 14, 2011 2:26:32 PM

Page 1

Work Order ID: 73105

Parent Item: D412-785-002-201

Parent Item Name: GPS Mount Assembly









Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP Rev:A 11.08.24 new issue DD verf:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
<input checked="" type="checkbox"/> D412-785-002-401 Faceplate		Manufactured	No			100	Each	2.0000	1	2			
<div> <div>  </div> <div> <p>673208</p> </div> <div>  </div> <div> <p>SO 11/09/14</p> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST	2						
						73208	2						
<input checked="" type="checkbox"/> D412-785-002-203 Angle Assembly		Manufactured	No			100	Each	2.0000	1	2			
<div> <div>  </div> <div> <p>673206</p> </div> <div>  </div> <div> <p>ES 11/09/14</p> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						FG	2						
						73206	2						
<input checked="" type="checkbox"/> D412-785-002-205 Angle Assembly		Manufactured	No			100	Each	2.0000	1	2			
<div> <div>  </div> <div> <p>673206</p> </div> <div>  </div> <div> <p>ES 11/09/14</p> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						FG	2						
						73207	2						
<input checked="" type="checkbox"/> MS20426AD5- RIVET	LCR 264553-4	Purchased	No			100	Each	4,884.000	4	8			
<div> <div>  </div> <div> <p>117992</p> </div> <div>  </div> <div> <p>ES 11/09/14</p> </div> </div>													
						<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>					
						ST316	4884						
						104374	1122						
						110398	3762						

Picklist Print

Wednesday, September 14, 2011 2:26:33 PM

Page 2

Work Order ID: 73105



Parent Item: D412-785-002-201



Parent Item Name: GPS Mount Assembly

Start Date: 8/26/2011

Required Date: 10/14/2011

Start Qty: 2.00

Required Qty: 2.00

50-018-1

Purchased

No

100

Each

8.0000

4

8



Stud

85 11 09 - 19

Location

Loc Qty

Loc Code

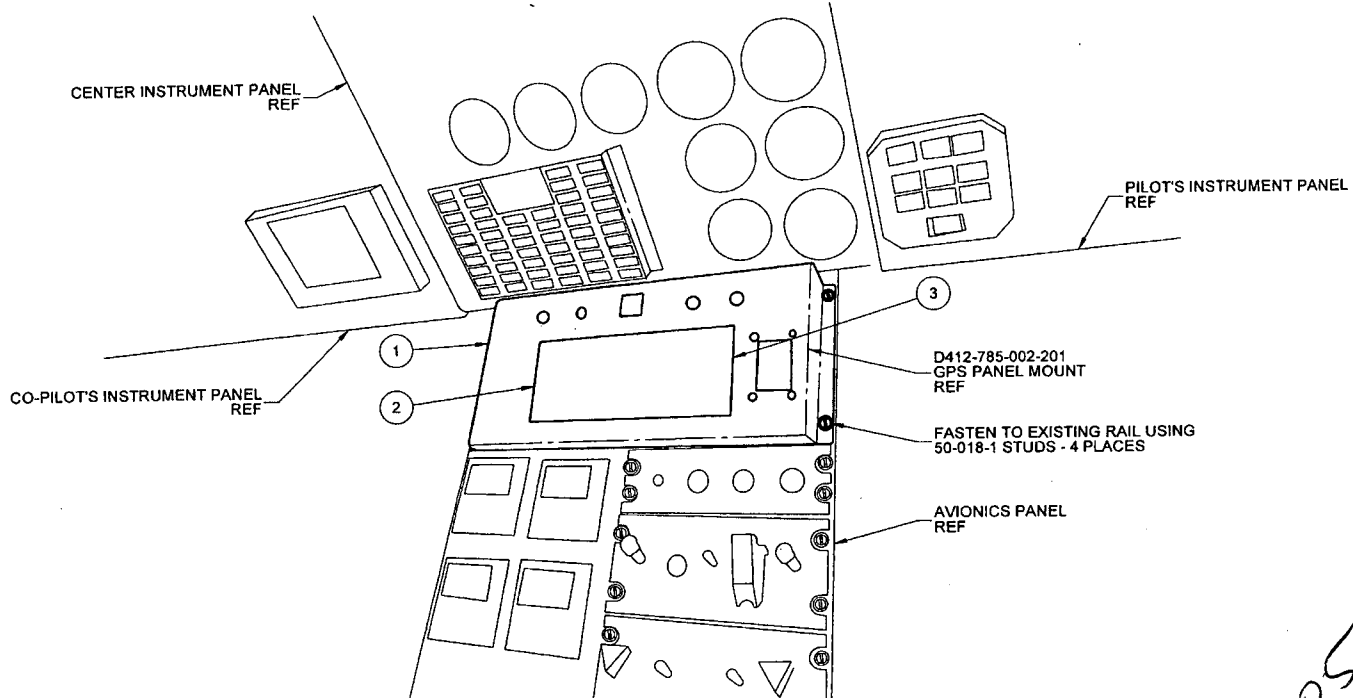
ST515

8

118756

8

X8



D412-785-002-101 GPS PANEL INSTALLATION

ITEM	QTY -101	PART NUMBER	DESCRIPTION
1	1	D412-785-002-201	GPS MOUNT ASSEMBLY
2	1	GPS400W	GPS
3	4	MS24963S49	SCREW

73105

RELEASED
10/18/25

B	UPDATE FOR LSTC	HS	09.10.09
A	NEW ISSUE	HS	08.12.09
REV.	DESCRIPTION	BY	DATE
DESIGN	RN	EAGLE COPTERS MAINTENANCE CALGARY, ALBERTA, CANADA	
DRAWN	HS	DRAWING NO.	REV. B
CHECKED	N/A	D412-785-002-101	SHEET 1 OF 8
MFG. APPR.	N/A	TITLE	SCALE
APPROVED	HS	GPS PANEL INSTALLATION	NTS
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DATE	09.10.09		

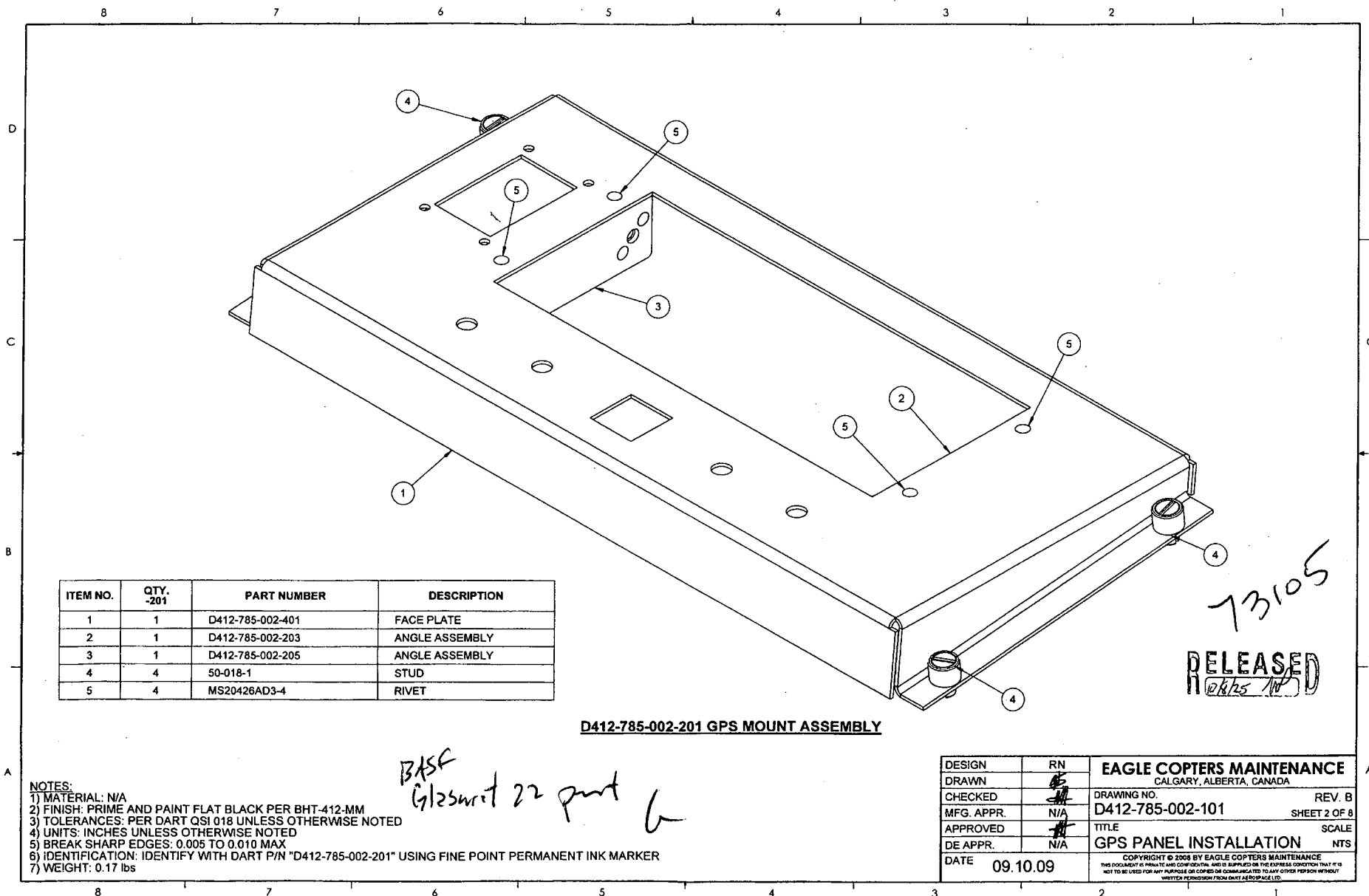
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



73105
 RELEASED
 10/8/25

BASE
 Glassurit 22 part

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

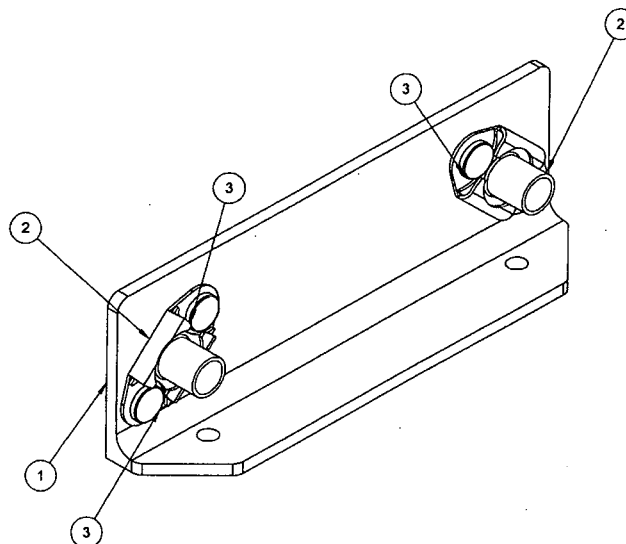
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -203	PART NUMBER	DESCRIPTION
1	1	D412-785-002-403	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET



D412-785-002-203 ANGLE ASSEMBLY

73105

RELEASED
12/6/25 N/A

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

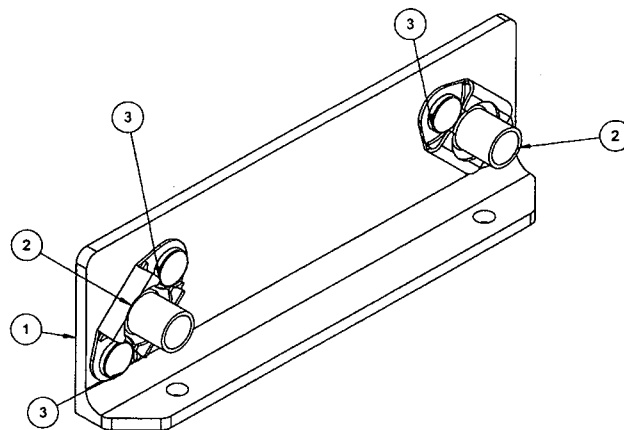
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

ITEM NO.	QTY. -205	PART NUMBER	DESCRIPTION
1	1	D412-785-002-405	ANGLE
2	2	MS21075L08	NUTPLATE
3	4	MS20426AD3-4	RIVET



D412-785-002-205 ANGLE ASSEMBLY

73105

RELEASED
10/6/25 MP

NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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CHECKED	JS	DRAWING NO.	REV. B
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APPROVED	JS	TITLE	SCALE
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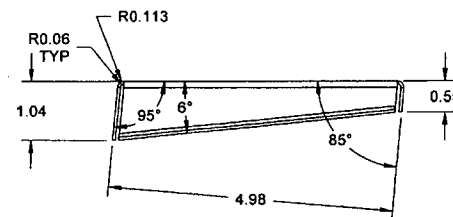
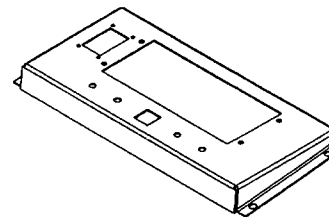
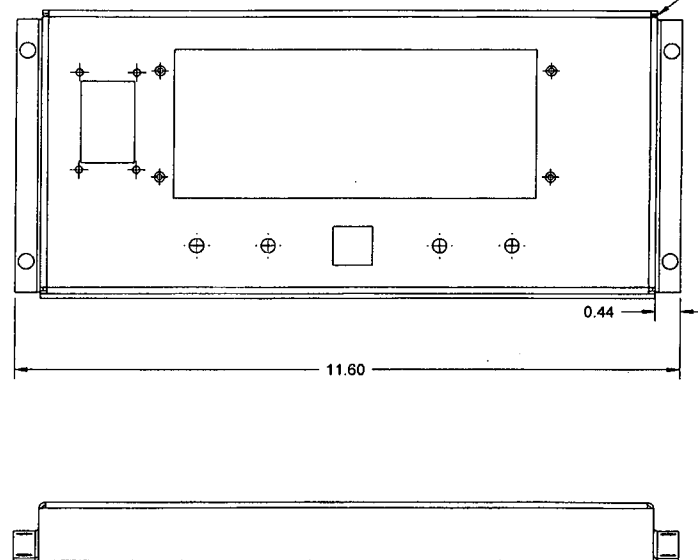
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-785-002-401 FACE PLATE
MADE FROM D412-785-002-401F

NOTES:

- 1) MATERIAL: MADE FROM D412-785-002-401F
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.11 lbs
- 8) WELD PER DART QSI 004

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
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MFG. APPR.	N/A	D412-785-002-101	SHEET 5 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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RELEASED
10/8/25

73105

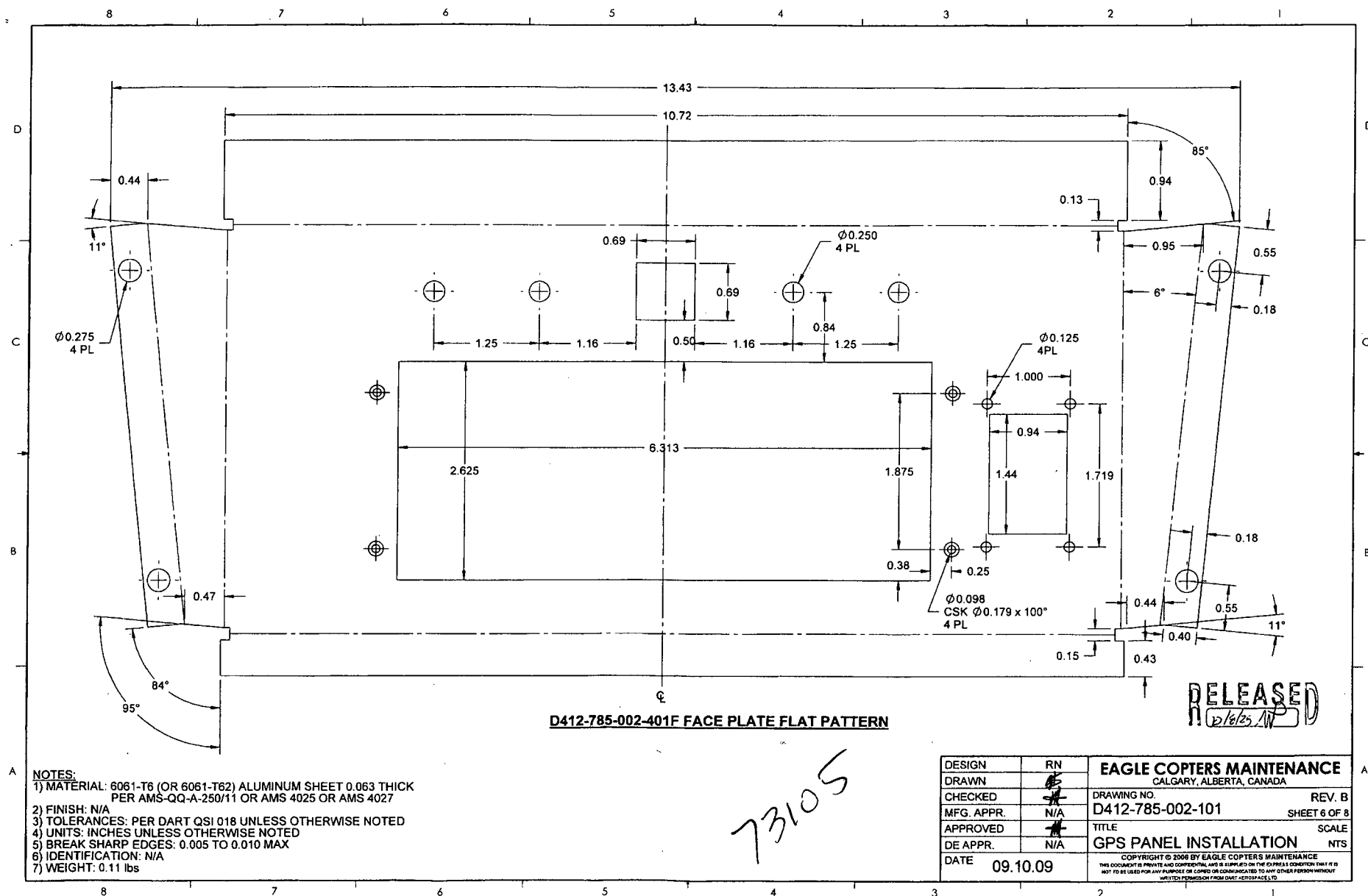
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



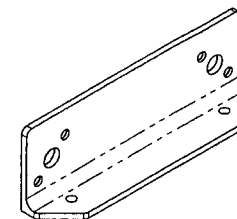
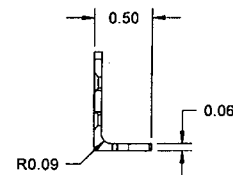
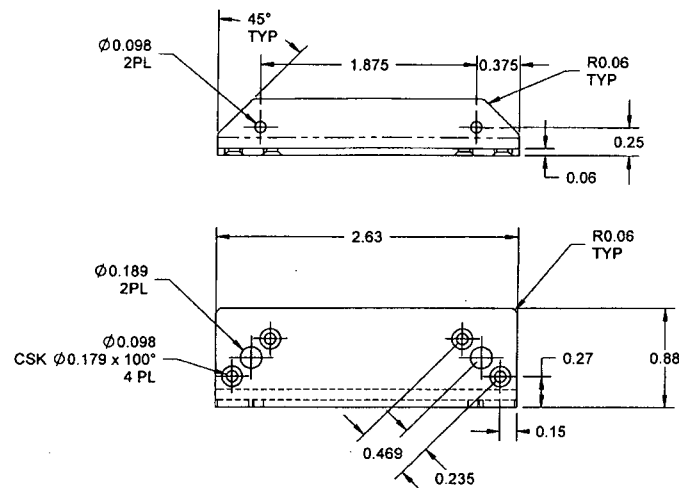
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DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-785-002-403 ANGLE

73105

RELEASED
06/25/10

NOTES:

- 1) MATERIAL: 6061-T6/T6510/6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: N/A
- 7) WEIGHT: 0.01 lbs

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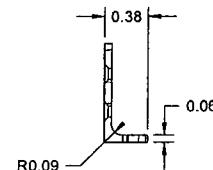
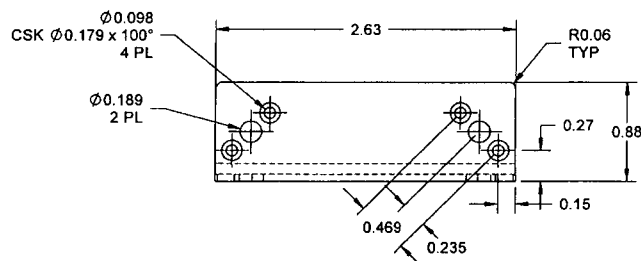
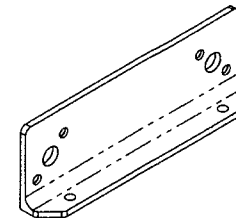
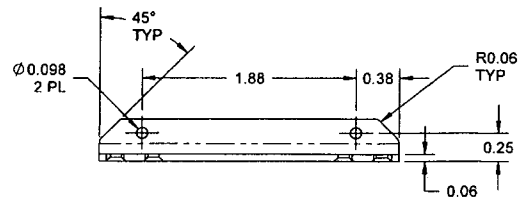
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



D412-785-002-405 ANGLE

73105

RELEASED
10/25/10

- NOTES:
- 1) MATERIAL: 6061-T6/6510/T6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8
 - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
 - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
 - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
 - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
 - 6) IDENTIFICATION: N/A
 - 7) WEIGHT: 0.01 lbs

DESIGN	RN	EAGLE COPTERS MAINTENANCE	
DRAWN	<i>[Signature]</i>	CALGARY, ALBERTA, CANADA	
CHECKED	<i>[Signature]</i>	DRAWING NO.	REV. B
MFG. APPR.	N/A	D412-785-002-101	SHEET 8 OF 8
APPROVED	<i>[Signature]</i>	TITLE	SCALE
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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: September 14, 2011 2:38 PM
To: L Lacelle
Subject: Cherry Rivets

Linda

The D412-785-002-203/-205 angle assemblies may be installed onto the D412-785-002-401 assembly using appropriate cherry rivets if required.

Regards,

Harvey Siemens
Mechanical Designer
DART Aerospace Ltd.

P: 403-717-0328
F: 403-717-1288
E: hsiemens@dartaero.com
W: www.dartaero.com
M: 1060 McTavish Road NE, Calgary, Alberta, T2E 7G6

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W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Linda Lacelle

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: September 15, 2011 8:48 AM
To: L Lacelle
Subject: Paint

Linda

It is acceptable to use BSAF Glasurit 22 (flat black) paint on the D412-785-002-401 GPS mount assembly

Regards,

Harvey Siemens
Mechanical Designer
DART Aerospace Ltd.

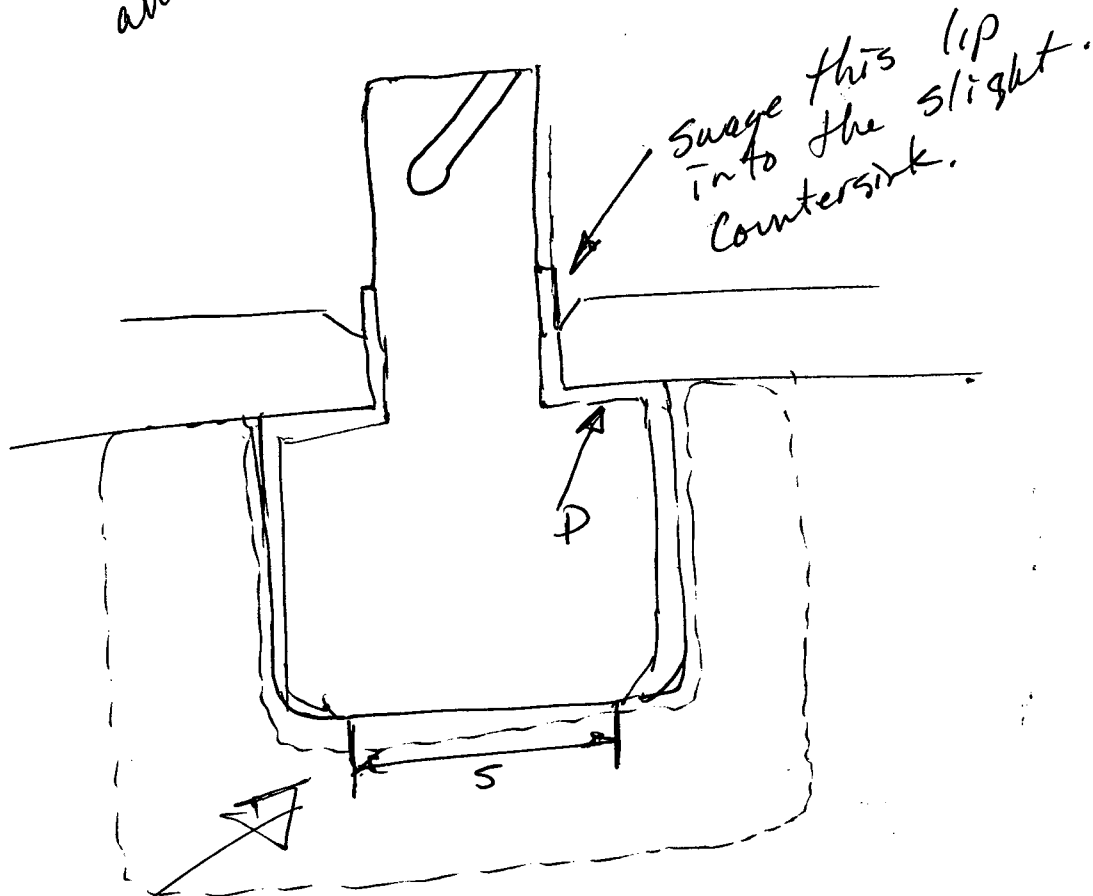
P: 403-717-0328
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ATTACH TO w/o phase

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Call me if you have questions.
403-717-0328

Best to push on
the stud only with
the other side of the
anvil.



Eagle has had the best luck swaging
these with the enclosed tool when
they press against the stud (S)
rather than across the whole cup. The
other style that they HAVE NOT had luck
with is the style illustrated by the dotted lines
IT tends to squash the stud @ area "D"

TABLE 1. WASHER DIMENSIONS AND DASH NUMBERS

FED. SUP. CLASS

5310

BOLT OR SCREW SIZE	A DIA .010	B +.070 -.005 DIA	T	DASH NUMBERS							
				CARBON STEEL	CORROSION RESISTANT STEEL		CHEMICAL CONVERSION COATING	ALUMINUM ALLOY		WITREATED	BRASS
					UNHEATED PASSIVATED	COATED		ANODIZED SURFACES	TREATED SURFACES		
NO. 2	.099	.250	.016 .032	2L 2	C2L 2	XC2L 2	JD2L 2	KD2L KD2	PD2L PD2	02L 02	B2
NO. 3	.105	.250	.016 .032	3L 3	C3L C3	XC3L XC3	JD3L JD3	KD3L KD3	PD3L PD3	03L 03	B3
NO. 4	.125	.312	.016 .032	4L 4	C4L C4	XC4L XC4	JD4L JD4	KD4L KD4	PD4L PD4	04L D4	B4
NO. 5	.140	.438	.042	5	C5	XC5	JD5	KD5	PD5	05	B5
NO. 6	.149	.375	.016 .032	6L 6	C6L C6	XC6L XC6	JD6L JD6	KD6L KD6	PD6L PD6	06L 06	B6
NO. 8	.174	.375	.016 .032	8L 8	C8L C8	XC8L XC8	JD8L JD8	KD8L KD8	PD8L PD8	08L 08	B8
NO. 9	.188	.500	.049	9	C9	XC9	JD9	KD9	PD9	09	B9
NO. 10	.203	.438	.016 .032 .063	10L 10	C10L C10	XC10LL XC10L XC10	JD10LL JD10L JD10	KD10LL KD10L KD10	PD10L PD10	010L 010	B10
NO. 11	.234	.625	.065	11	C11	XC11	JD11	KD11	PD11	011	B11
1/4	.265	.500	.016 .032 .063	416L 416	C416L C416	XC416L XC416	JD416L JD416	KD416L KD416	PD416L PD416	0416L 0416	B416
5/16	.328	.562	.016 .032 .063	516L 516	C516L C516	XC516L XC516	JD516L JD516	KD516L KD516	PD516L PD516	0516L 0516	B516
3/8	.390	.625	.016 .032 .063	616LL 616L 616	C616LL C616L C616	XC616LL XC616L XC616	JD616L JD616	KD616L KD616	PD616L PD616	0616L D616	B616
7/16	.453	.750	.016 .032 .063	716L 716	C716L C716	XC716LL XC716L XC716	JD716L JD716	KD716L KD716	PD716L PD716	0716L D716	B716
1/2	.515	.875	.016 .032 .063	816L 816	C816L C816	XC816L XC816	JD816L JD816	KD816L KD816	PD816L PD816	0816L 0816	B816
9/16	.578	1.062	.016 .032 .063	916L 916	C916L C916	XC916L XC916	JD916L JD916	KD916L KD916	PD916L PD916	0916L 0916	B916
5/8	.640	1.188	.016 .032 .063	1016L 1016	C1016L C1016	XC1016L XC1016	JD1016L JD1016	KD1016L KD1016	PD1016L PD1016	01016L D1016	B1016
3/4	.765	1.312	.016 .032 .095	1216L 1216	C1216L C1216	XC1216L XC1216	JD1216L JD1216	KD1216L KD1216	PD1216L PD1216	01216L D1216	B1216
7/8	.890	1.500	.016 .032 .099	1416L 1416	C1416L C1416	XC1416L XC1416	JD1416L JD1416	KD1416L KD1416	PD1416L PD1416	01416L D1416	B1416
1	1.015	1.750	.016 .032 .090	1616L 1616	C1616L C1616	XC1616L XC1616	JD1616L JD1616	KD1616L KD1616	PD1616L PD1616	01616L D1616	B1616
1-1/16	1.078	1.812	.016 .032 .090	1716L 1716	C1716L C1716	XC1716L XC1716	JD1716L JD1716	KD1716L KD1716	PD1716L PD1716	01716L D1716	B1716
1-1/8	1.140	1.875	.016 .032 .090	1816L 1816	C1816L C1816	XC1816L XC1816	JD1816L JD1816	KD1816L KD1816	PD1816L PD1816	01816L D1816	B1816
1-1/4	1.265	2.000	.016 .032 .090	2016L 2016	C2016L C2016	XC2016L XC2016	JD2016L JD2016	KD2016L KD2016	PD2016L PD2016	02016L D2016	B2016
1-5/16	1.378	2.062	.016 .032 .090	2116L 2116	C2116L C2116	XC2116L XC2116	JD2116L JD2116	KD2116L KD2116	PD2116L PD2116	02116L D2116	B2116
1-7/8	1.640	2.375	.016 .032 .090	2616L 2616	C2616L C2616	XC2616L XC2616	JD2616L JD2616	KD2616L KD2616	PD2616L PD2616	02616L D2616	B2616
1-7/8	1.890	2.625	.016 .032 .090	3016L 3016	C3016L C3016	XC3016L XC3016	JD3016L JD3016	KD3016L KD3016	PD3016L PD3016	03016L D3016	B3016
2-1/4	2.265	3.000	.016 .032 .090	3616L 3616	C3616L C3616	XC3616L XC3616	JD3616L JD3616	KD3616L KD3616	PD3616L PD3616	03616L D3616	B3616
2-1/2	2.515	3.250	.016 .032 .090	4016L 4016	C4016L C4016	XC4016L XC4016	JD4016L JD4016	KD4016L KD4016	PD4016L PD4016	04016L D4016	B4016

P.A.
NAVY-AS
CUSTODIANS:
ARMY-AV
NAVY-AS
AIR FORCE-99
PROCUREMENT SPECIFICATION

AIR FORCE-NAVY AERONAUTICAL STANDARD

WASHER, FLAT

AN 960

SHEET 3 OF 3

APPROVED 18 FEB 42 REVISED 21 FOR CHANGES SEE SHEET 1



Linda Lacelle

From: Harvey Siemens <hsiemens@dartaero.com>
Sent: September 15, 2011 11:13 AM
To: L Lacelle
Subject: 50-018-1 Stud Swaging
Attachments: 20110915091055770.pdf

Linda

These are the swaging instructions. You might be able to get them done without the tool. The countersink doesn't have a specific size but they tell me that it's just a heavy deburr on the backside.

Hope that helps.

Regards,

Harvey Siemens
Mechanical Designer
DART Aerospace Ltd.

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-----Original Message-----

From: di_herculis@dartaero.com [mailto:di_herculis@dartaero.com]
Sent: September-15-11 3:11 AM
To: Harvey Siemens
Subject:

This E-mail was sent from "RNPED6363" (Aficio MP 2000).

Scan Date: 09.15.2011 09:10:55 (+0000)
Queries to: di_herculis@dartaero.com

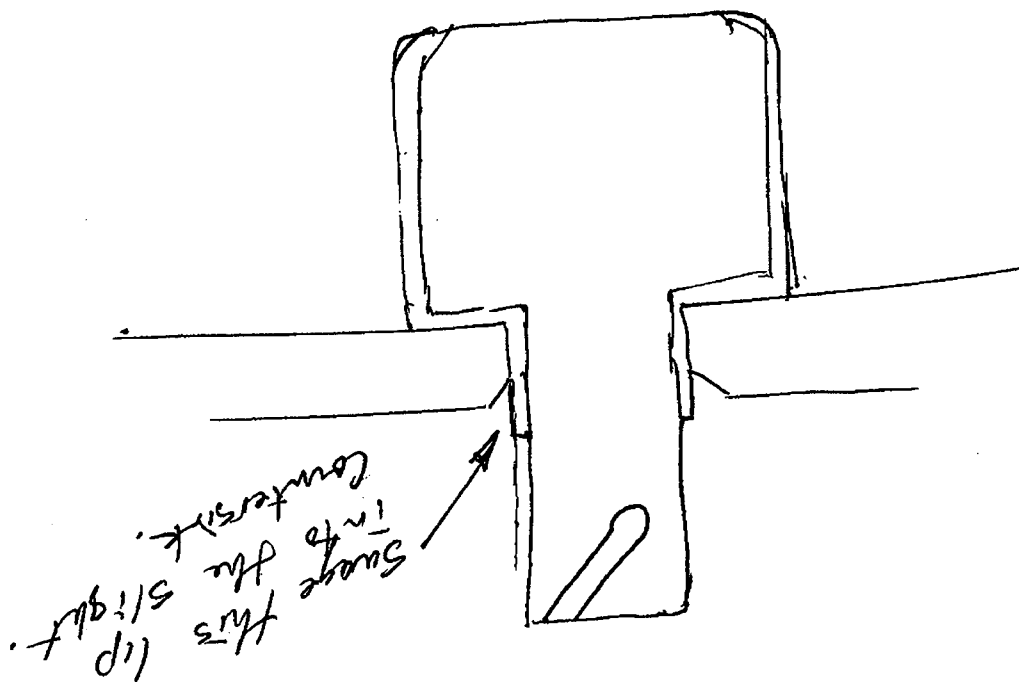
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries